

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

11-755
 Part No: D3531-041 PAR #: N/A Fault Category: SMALL FAB NCR: Yes No DQA: Yes Date: 9/16/2011
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: Yes Date: 11/08/10

NCR: 72521		WORK ORDER NON-CONFORMANCE (NCR) \$6.60						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/08/03	100	1 part of 3531-3 is swapped over R.C. process.	<u>L</u> 11/08/03 GS1042	SCRAP part	<u>SB</u> 11/08/03	<u>S</u> 11/08/03	<u>L</u> 11/08/03	<u>S</u> 11/08/03

NOTE: Date & initial all entries

Work Order ID 72521

Thursday, July 28, 2011 9:16:48 AM



Page 2

Item ID: D3531-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 7/28/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7x Ø m/h 11/08/03

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

SHIP
P.O. 5602

11/08/03

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/03

11-05-3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, July 28, 2011 9:16:54 AM

Page 1

Work Order ID: 72521

Parent Item: D3531-041

Parent Item Name: Bracket Assembly







Start Date: 7/28/2011

Required Date: 8/3/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 		Manufactured	No			100	Each	0.0000	1	7			
Bracket						B 71977					SB 11/6/03		
D3531-3 		Manufactured	No			100	Each	0.0000	1	7			
Bracket Front Plate						D 71978					SB 11/6/03		
MS20470AD4-4 		Purchased	No			100	Each	1,060.000	12	84			
Rivet, Universal Head											SB 11/6/03		

Location

Loc Qty

Loc Code

ST139

518

117423

518

ST319

542

116188

476

116391

66

84

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DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED HA	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

△
TRANSFER DRILL #9 (Ø0.196)



TRANSFER DRILL #30 (Ø0.129)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)

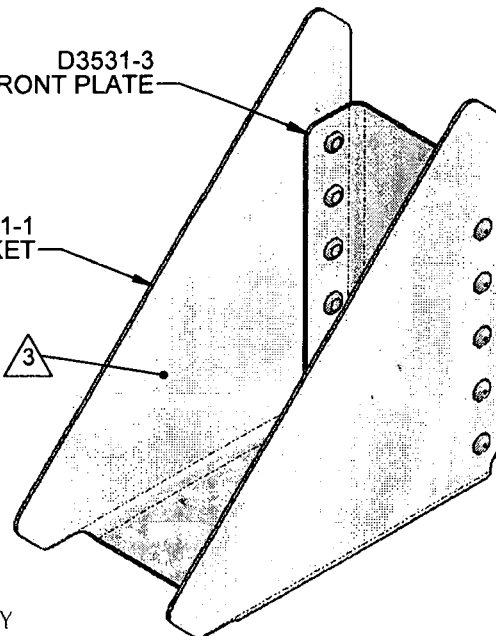
△
4

RELEASED
07-08-03

D3531-3
BRACKET FRONT PLATE

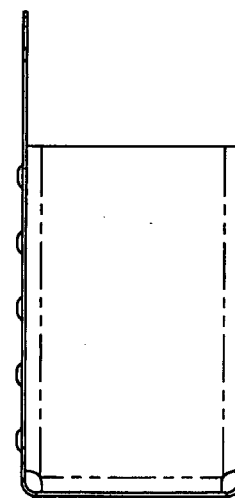
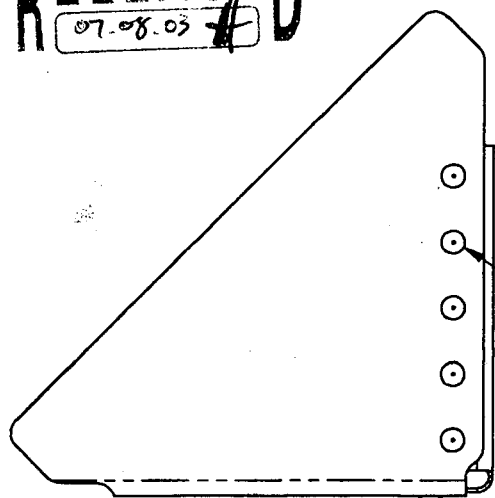
D3531-1
BRACKET

△
3



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72521

MS20470AD4-4
(10 PLACES)



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

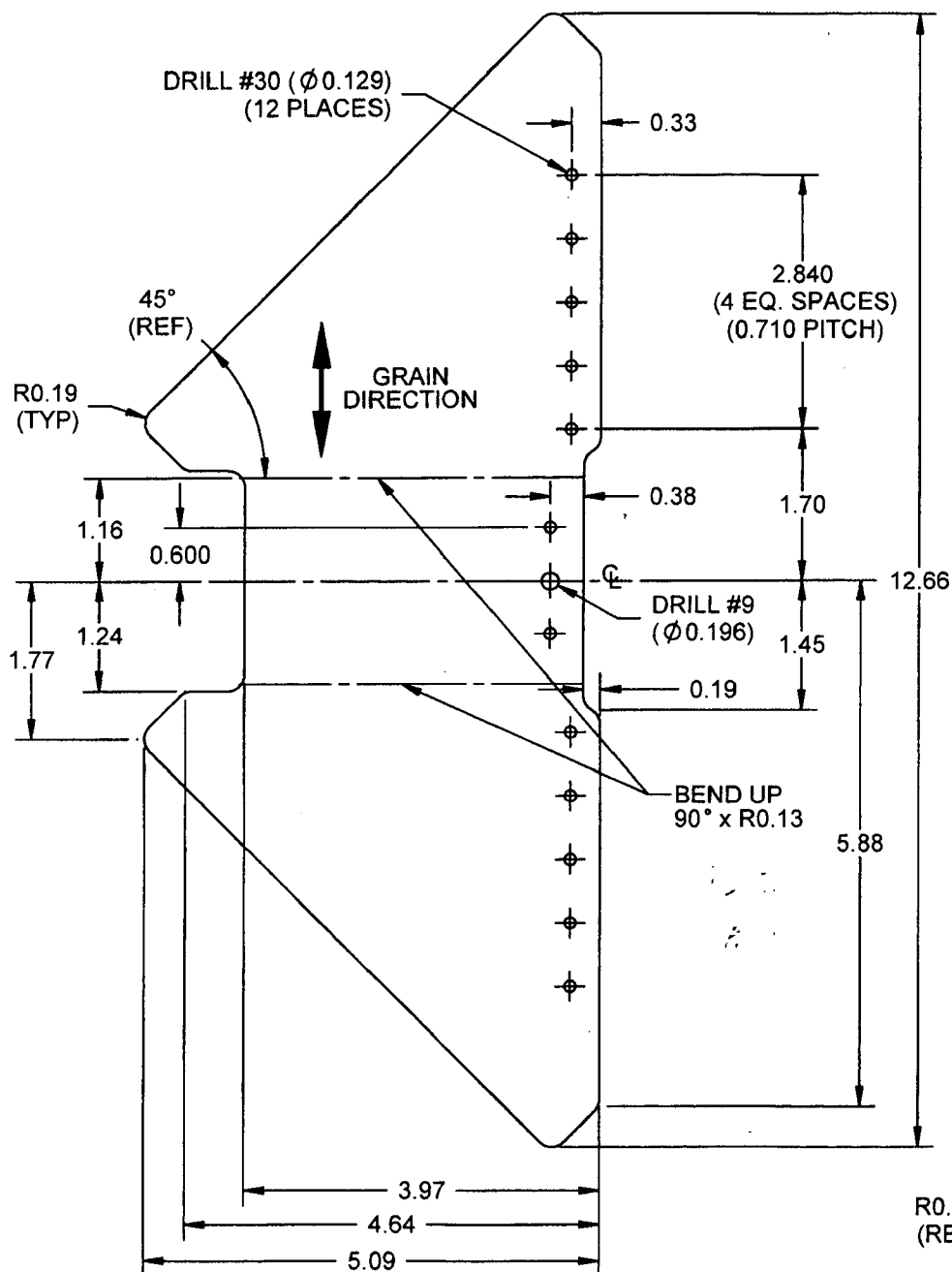
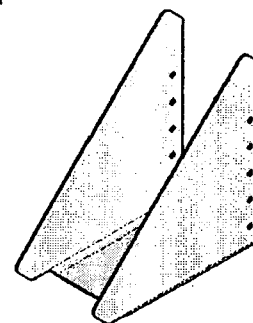
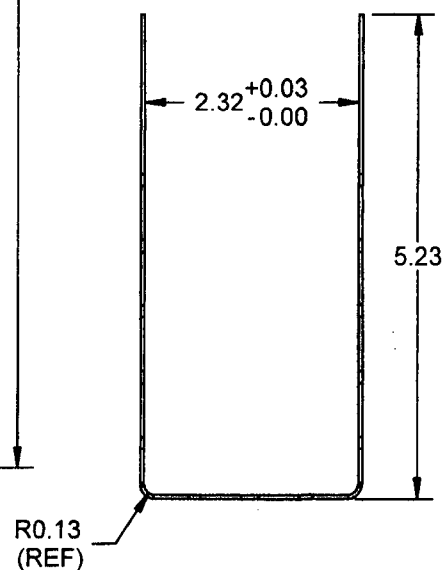
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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED HA	DRAWING NO. D3531	REV. A
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SHEET 2 OF 3 SCALE 1:2

**D3531-1F FLAT PATTERN****RELEASED**
07-08-03**D3531-1 BRACKET****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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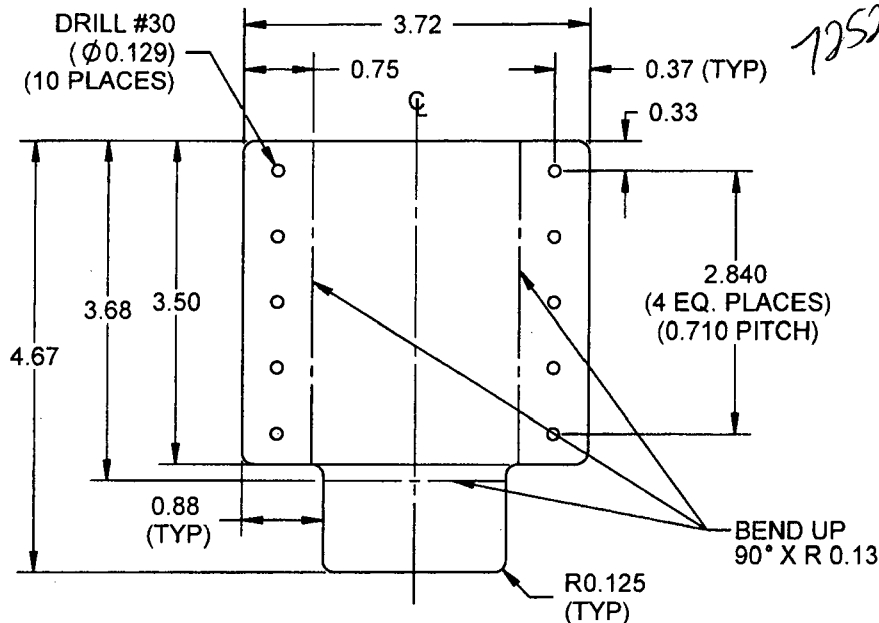
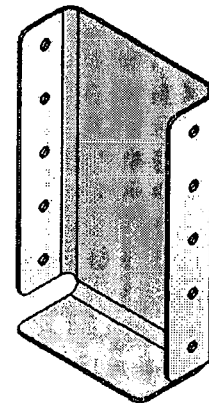
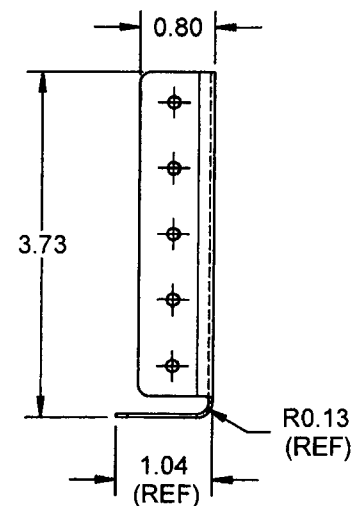
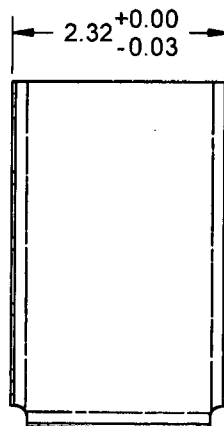
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DART

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CHECKED CE	APPROVED #	DRAWING NO. D3531	REV. A
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SHEET 3 OF 3 SCALE 1:2

**RELEASED**
07.08.03 #**D3531-3F FLAT PATTERN****D3531-3 BRACKET FRONT PLATE****NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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